

Date: Monday, 07/04/2008 11:47:05 AM
 User: Julie Lecocq

Process Sheet

| | | | |
|------------------------------------|---|---------------------------|---------------|
| Customer : | CU-DAR001 Dart Helicopters Services | Drawing Name : | AFT CROSSTUBE |
| Job Number : | 38426 | | |
| Estimate Number : | 10377 | | |
| P.O. Number : | | Part Number : | D2890 |
| This Issue : | 07/04/2008 | S.O. No. : | |
| Prsht Rev. : | NC | Drawing Number : | D2890 REV B |
| First Issue : | / / | Project Number : | N/A |
| Previous Run : | 38425 | Drawing Revision : | B |
| | Type : | Material : | |
| | PURCHASED PARTS | Due Date : | 10/05/2008 |
| Written By : | | Qty: | 1 Um: Each |
| Checked & Approved By : | JL 08.4.06 | | |
| Comment : | Est. D 05.03.21 Removed Bending procedures KJ/JLM | | |

Additional Product

Job Number:



| | | |
|----------------|------------------------------|----------------------|
| Seq. #: | Machine Or Operation: | Description : |
|----------------|------------------------------|----------------------|

| | | |
|-----|----------|---------------------|
| 1.0 | D6008180 | Crosstube extrusion |
|-----|----------|---------------------|



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

| | | | |
|-----|-----------|---------------------|-------|
| Qty | Part # | Description | Batch |
| 1 | D6008-180 | Crosstube extrusion | 40221 |

DP 8-7-24

| | | |
|-----|---------|-----------------------------|
| 2.0 | BENDING | BENDING MACHINE - SKIDTUBES |
|-----|---------|-----------------------------|



Comment: BENDING MACHINE

1-Bend D2890 as per Dwg D2890 and Folio FT002

| | | |
|-----|-----|-------------------|
| 3.0 | QC6 | DIMENSIONAL CHECK |
|-----|-----|-------------------|



Comment: DIMENSIONAL CHECK

8-7-24

| | | |
|-----|-------------|-----------------------|
| 4.0 | SKIDTUBES 1 | SKIDTUBESS RESOURCE 1 |
|-----|-------------|-----------------------|



Comment: LANDING GEAR RESOURCE 1

1-Deburr and Polish

| | | |
|-----|-----------------|----------------------------|
| 5.0 | HAND FINISHING1 | HAND FINISHING RESOURCE #1 |
|-----|-----------------|----------------------------|



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

N/A

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT CROSSTUBE

Job Number: 38426

Part Number: D2890

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



N/A



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: W/O 40738

(-107)

208-A-24 (1)

8.0

QC21

FINAL INSPECTION/W/O RELEASE



08/07/24 JF

Comment: FINAL INSPECTION/W/O RELEASE

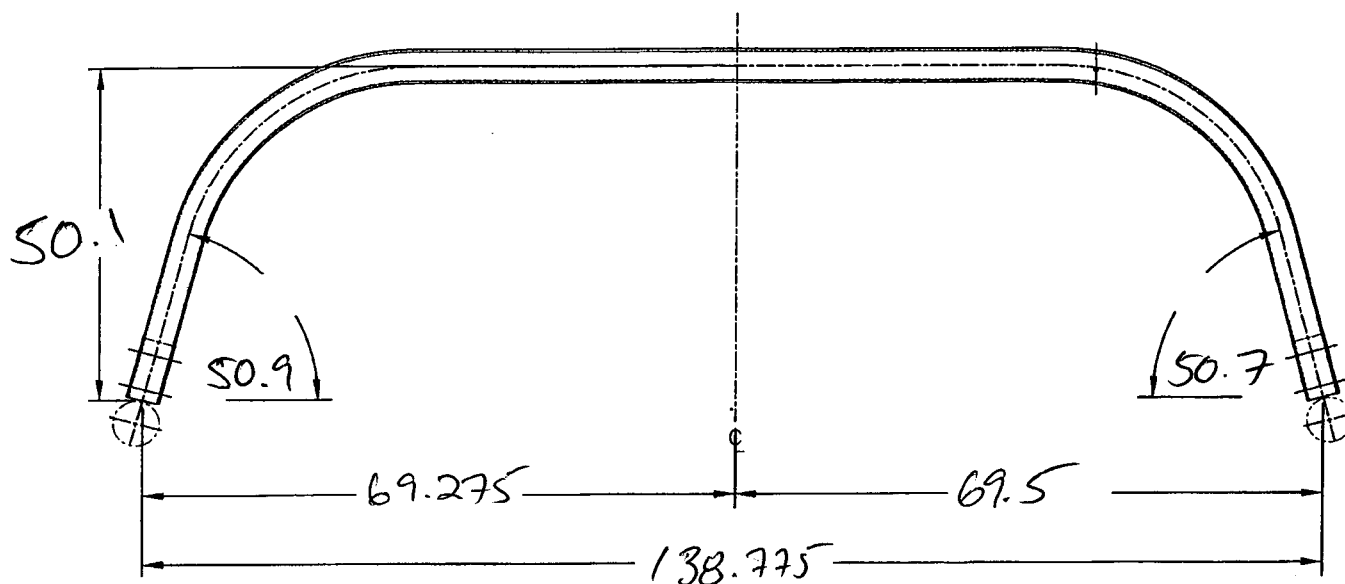
Job Completion



mf 08-07-24

| | | | |
|----------------------------|--|--------------|-------------|
| DART AEROSPACE LTD | | Work Order: | 38426 |
| Description: Crosstube Aft | | Part Number: | D2890 |
| Inspection Dwg: D2890 | | Rev: B | Page 1 of 1 |

| Required Dimension | Min | Max |
|--------------------|--------|--------|
| Height | 49.875 | 50.125 |
| 1/2 Span | 69.275 | 69.525 |
| Angle | 49 | 52 |
| Total Span | 138.55 | 139.05 |



| Comments |
|----------|
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| |
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| |

| | |
|-----------------|---------|
| QC15 Inspection | |
| Date | 0804-24 |

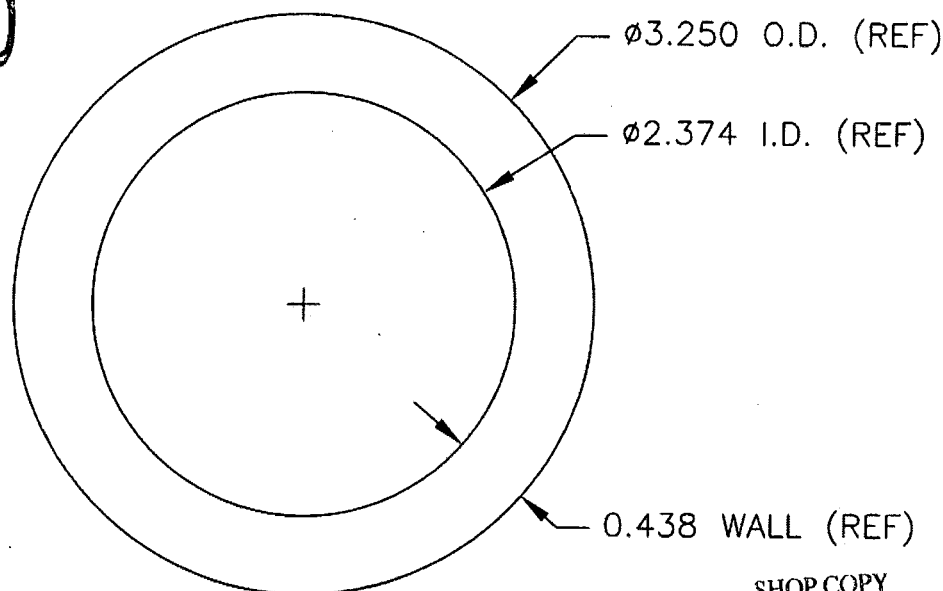
| Rev | Date | Change | Revised by | Approved |
|-----|----------|-----------|------------|----------|
| A | 07.02.06 | New Issue | KJ/JM | |



| | | | |
|------------------|----------------|---|------------------------|
| DESIGN CP | DRAWN BY CP | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED # | APPROVED # | DRAWING NO. D6008 | REV. A SHEET 1 OF 1 |
| DATE 00.11.17 | | TITLE CROSSTUBE MATERIAL SCALE 1:1 | |
| A | 00.11.17 | NEW ISSUE | |

SPECIFICATION CONTROL DRAWING

RELEASED
00.11.24 #



NOTES

- 1) D6008-XXX CROSSTUBE
LENGTH

WHERE XXX IS LENGTH IN INCHES
EG. 180" LONG TUBE: D6008-180

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NO. 38426

- 2) MATERIAL: 3.250 OD x 0.438 WALL 7075-T6/T6511 (WW-T-700/7 OR QQ-A-225/9 OR QQ-A-200/11) SEAMLESS ALUMINUM TUBE.
MINIMUM ULTIMATE TENSILE STRENGTH = 77 ksi
MINIMUM YIELD TENSILE STRENGTH = 66 ksi
- 3) TOLERANCES ARE PER ASTM B210 AS FOLLOWS:
O.D.: ± 0.008 MEAN (± 0.016 INCLUDING OVALITY)
WALL: ± 0.020 MEAN (± 0.044 INCLUDING ECCENTRICITY)
LENGTH: XXX $+0.125/-0.000$
STRAIGHTNESS: 0.010" DEVIATION / 12" LENGTH
- 4) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.
- 5) CHEMICAL CONVERSION COAT PER DART QSI 005 4.1

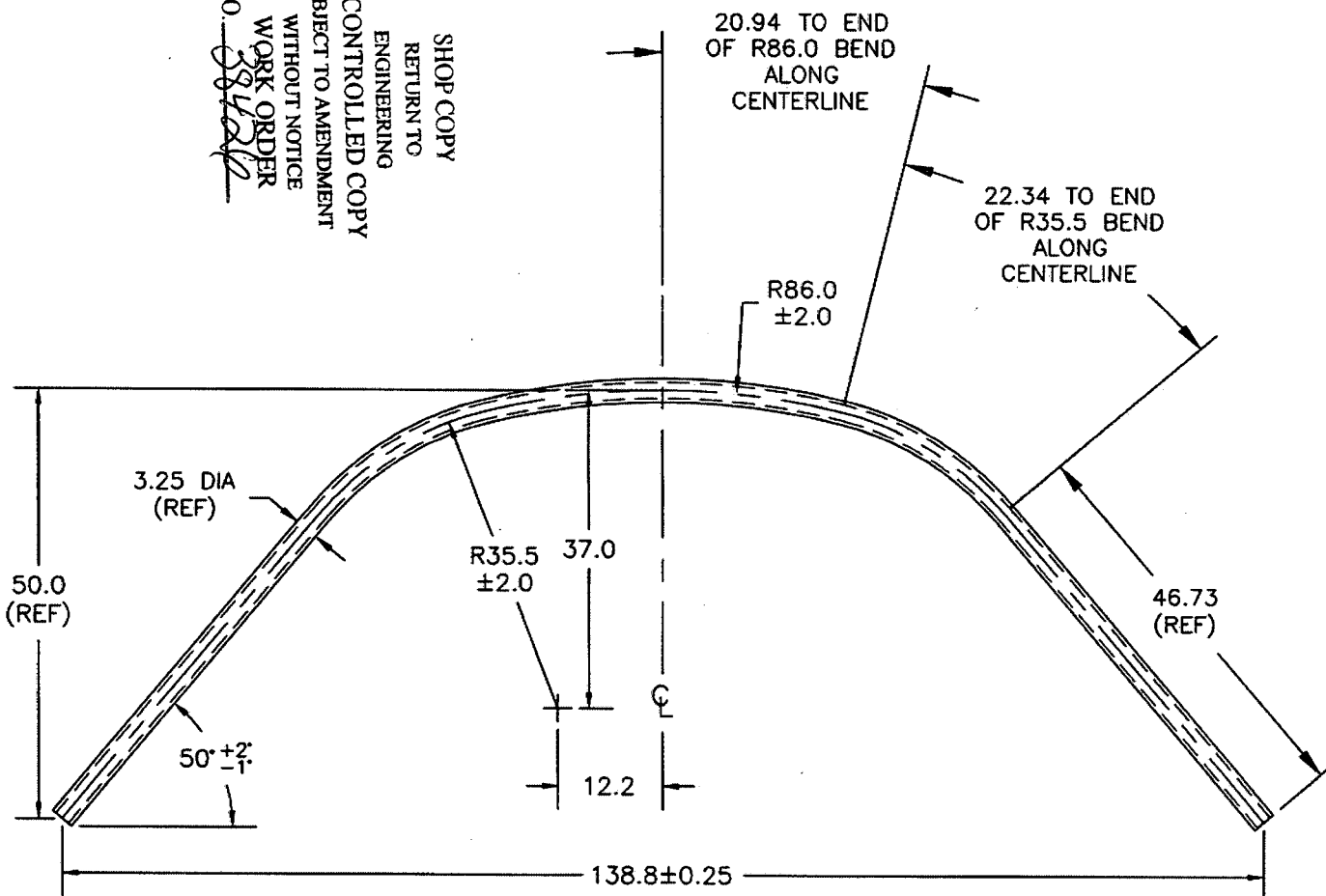
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RELEASED
02.10.28

| DESIGN | DRAWN BY | DART AEROSPACE LTD |
|-----------------------------------|---------------|-----------------------------|
| CHECKED | APPROVED | HAWKESBURY, ONTARIO, CANADA |
| DATE | TITLE | REV. B |
| 02.10.18 | AFT CROSSTUBE | SHEET 1 OF 1 |
| A | 99.05.21 | SCALE |
| B | 02.10.18 | 1:20 |
| ADD TANGENT LENGTHS; CHANGE NOTES | | |



NOTES

- 1) MATERIAL: MANUFACTURE FROM D6008-180 ($\phi 3.25$ OD x 0.438 WALL)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) PART IS SYMMETRIC ABOUT CENTERLINE
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) BEND PROGRESSIVELY WITH MINIMUM OF 3 PASSES
- 6) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.

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